

5105

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22235
<b>Description:</b> Arm	<b>Part Number:</b>	D3387-2
D3387		
<b>Dwg:</b> D2802 rev. A <i>B-A 05.01.25</i>	<b>Qty:</b>	2

*up 05.01.25*

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O 17.800"	<i>HD</i>	05.01.17	2
2	METAL	Cut blanks <del>15.800</del> long Material: 6061-T6 bar 6.00" x 0.50" Batch: <i>119601 111409 111768</i>	<i>ML</i>	05.01.18	2
3	HAAS	Machine as per folio FA101	<i>ML</i>	05.01.19	2
4	CNC-CELL	Counter sink .375 dia as per dwg	<i>ML</i>	05.01.19	2
5	QC	Inspect Level 2	<i>ML</i>	05.01.19	2
6	QC	Inspect Level 8	<i>ML</i>	05.01.19	2
7	METAL	Tumble & Deburr <b>NO</b> sharp edges.	<i>U</i>	05.01.20	2
8	QC	Inspect Level 5	<i>ML</i>	05.01.20	2
9	FINISHING	Chemical conversion coat as per QSI 005 4.3	<i>PD</i>	05-01-20	2
10	STORES	Identify and stock	<i>PD</i>	05-01-20	2
11	EXPEDITING	Close W/O Inspect level 21 Cost / part: <i>122.13</i> <i>54c 05/01/21</i> <i>(2)</i> 72.86	<i>HD</i>	05.01.21	2

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	
B	02.03.18	Re-format	NG	<i>02-03-18</i>

**RELEASED**

*02/03/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mg	Approval QC Inspector
05.01.18	2	Permanent change	<i>[Signature]</i>	05.01.18	N/A	<i>[Signature]</i> p-050142	<i>[Signature]</i> 05.01.27

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.01.19	3	1 piece scrap 1 time to run the program	<i>[Signature]</i> p-050142	destroy & replace	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> 05.01.19	<i>[Signature]</i> p-050142	<i>[Signature]</i> 05.01.19

Part No: ~~D2802~~

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes ☒ No ☐

DQA: *[Signature]*

Date: 05/01/19

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order: 22235
Description: Arm		Part Number: <del>D2802</del> D3397-2
Inspection Dwg: D2802 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	$\pm 0.010$	0.503	—		Vern	
7.577	$\pm 0.010$	7.580	—		H-G	
R0.030	$\pm 0.010$	R0.030	—		R-G	
$\varnothing 0.191$	$\pm 0.005$ $\pm 0.000$	$\varnothing 0.194$	—		Vern	
1.700	$\pm 0.010$	1.706	✓		Vern	
0.188	$\pm 0.010$	0.189	✓		Vern	
11.405	$\pm 0.010$	11.405	✓		Vern	
$\varnothing 0.507$	$\pm 0.000$ $\pm 0.001$	$\varnothing 0.5067$	✓		Micro/T-6	
2.033	$\pm 0.005$	2.032	—		Vern	
R0.300	$\pm 0.010$	R0.300	✓		R-G	
1.000	$\pm 0.005$	1.003	—		Vern	
2.000	$\pm 0.010$	<del>2.000</del> 2.005	✓		Vern	
1.347	$\pm 0.005$	1.347	—		Vern	
0.250	$\pm 0.010$	0.250	✓		Vern	
R0.125	$\pm 0.010$	R0.125	✓		Vern	
0.125	$\pm 0.010$	0.128	✓		Vern	
R0.032	$\pm 0.010$	R0.032	—		R-G	
$\varnothing 0.375 \times 100^\circ$	$\pm 0.010$	$\varnothing 0.377$	—		Vern	
0.500	$\pm 0.010$	0.500	✓		Vern	
0.300	$\pm 0.010$	0.300	—		Vern	

Measured by: <i>ML</i>	Audited by: <i>EP</i>	Prototype Approval: <i>AP</i>
Date: 05/01/19	Date: 05/01/19	Date: 05.01.19
Rev A	Change New Issue	Revised by KJ/JLM
		Approved

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 17, 2005  
10:23 am

Work Order No : 0022235  
Project Name : D2802-2  
Project For : WK505  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2802-2  
Description : Arm  
Manufactured : Yes  
Amount Req'd : 2  
Amount Done : 0  
Start Date : 01-17-05  
Est Finish Date : 01-24-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00